

Work Order ID 71843

Wednesday, July 13, 2011 10:21:03 AM

Page 1

Item ID: D3503-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Cup

Start Date: 7/14/2011 Start Qty: 60.00

Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 60.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 11-07-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3503	Rev A
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100		0.00
-----	--	------

Hardinge CNC LATHE SMALL

Hardinge	Memo	0.00
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Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA635 & DWG D3503,
FOLIO REV: A
DWG REV: A
2-DEBURR AS REQUIRED

110		0.00
-----	--	------

QC2- Inspect parts off machine FAI/FAIB

QC	Memo	0.00
----	------	------

Quality Control

120		0.00
-----	--	------

QC8- Inspect parts - second check

QC	Memo	0.00
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Quality Control

64
63

64
63

64

11/8/12

11/8/12

11/08/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3503-1

Accept



Setup Start



Revision ID:

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Item Name: Cup

Start Date: 7/14/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging Packaging	Memo	0.00				11/8/3		sf	(64)
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00				ck	11/08/04		

11-08-2
(64)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, July 13, 2011 10:21:00 AM

Work Order ID: 71843

Parent Item: D3503-1

Parent Item Name: Cup




Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 06-05-04 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000  304 round bar 1.00		Purchased	No			100	f	62.8500	0.065	4.105263		7/18/2	

Location

Loc Qty

Loc Code

MAT029

62.85

109508

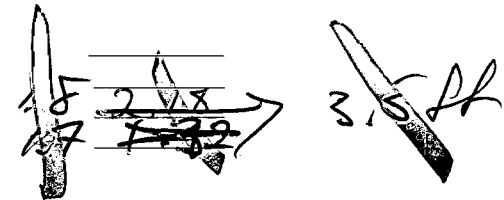
12.5

109541

2.18

113457

48.17



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

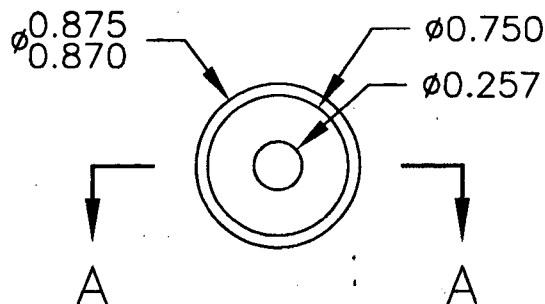
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

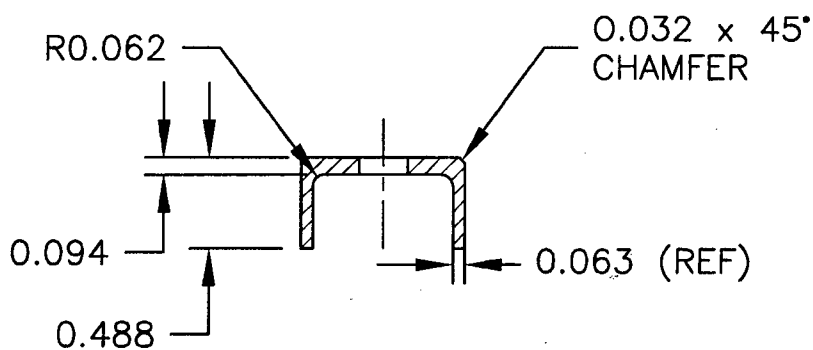


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3503	REV. A SHEET 1 OF 1
DATE 06.04.19		TITLE CUP	SCALE 1:1
A	06.04.19	NEW ISSUE	

06.04.19 *[Signature]*



D3503-1



SECTION A-A

#71843

D3503-1 CUP

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART MATERIAL SPEC M304RX.XXX)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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